

# Work Order ID 50525



Page 1

July 14, 2009 8:39:20 AM

Item ID: D3789-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 14/07/2009 Start Qty: 7.00

Cust Item ID:

Required Date: 20/07/2009 Req'd Qty: 7.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]* 09-07-14

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D3789	Rev A

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut extrusion to 1.250"

0.00

(B43722) mms 09/07/15

7

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA834

Dwg Rev: A

Folio Rev: AA

Deburr






0.00

2.5 09/07/16

**Work Order ID 50525**

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Item ID: D3789-1      Accept            Setup      Start        
Revision ID: A      Stop        
Item Name: Clamp  
Start Date: 14/07/2009      Start Qty: 7.00            Cust Item ID:  
Required Date: 20/07/2009      Req'd Qty: 7.00            Customer:

Reference:

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_  
                 QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_

Run      Start        
Stop      

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00							
			JP 09/07/16						
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00							
			JL 09/07/17						
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
			UMO 09/07/20 (X7)						

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Cust Item ID:

Required Date: 20/07/2009 Req'd Qty: 7.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-07-20

(7)

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\*\*\*Mask bearing bore prior to powder coat\*\*\*\*\*

START TIME: 1:25

OVENTEMPERATURE: 320°

FINISH TIME: 1:55

BR 09-07-20 (7)

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 09/07/20 (7)

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Start Date: 14/07/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 20/07/2009 Req'd Qty: 7.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- press fit D2611 bearing after powder coat  
2- stake D2611 bearing 4 places each side as per dwg D3789

8/509/07/20 (7)

180



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

=> 509/07/20

(47)

f

190



Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

Packaging

8/9/20 (7)

**Work Order ID 50525**

July 14, 2009 8:39:20 AM



Page 5

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Setup Start



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Stop



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Start Date: 14/07/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 20/07/2009 Req'd Qty: 7.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/2009 [Signature]  
MF 09-07-20

# Picklist Print

Page 1

July 14, 2009 8:39:20 AM

Work Order ID: 50525



Parent Item: D3789-1RevA



Parent Item Name: Clamp

Start Date: 14/07/2009

Required Date: 20/07/2009

Comments:

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423RevB1 		Manufactured	No			170	f	767.4300	0.5158			
Lug Extrusion												

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

767.43

43722

219.5

(B43722)

44529

22.39

45800

525.54

7

muf 09/07/15

D2611RevC

Manufactured No



Bearing

100

Each

31.0000

7.0000



Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

31

46841

31

50525

7 muf 09-07-20

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 50525
<b>Description:</b> Clamp		<b>Part Number:</b> 13789-1
<b>Inspection Dwg:</b> A	<b>Rev:</b> AA	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

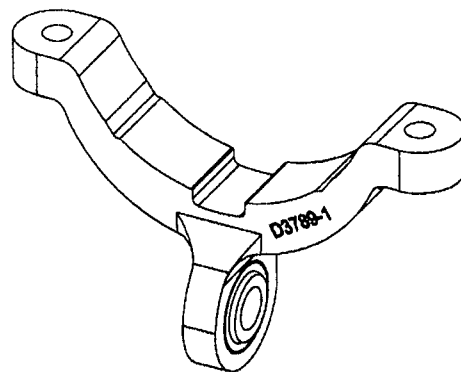
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	±.03	4.206	✓			
3.45	±.03	3.450	✓			
.31	±.03	.312	✓			
.75	±.03	.756	✓			
.38	±.03	.376	✓			
.40	±.03	.400	✓			
R1.47	±.03	1.470	✓			
2.07	±.03	2.077	✓			
1.12	±.03	1.126	✓			
.56	±.03	.561	✓			
Ø .257	+ .005 - .000	.259	✓			
Ø .8115	+ .8115 - .8110	.811	✓			
R .20	±.03	.200	✓			
R .06	±.03	.06	✓			
R .25	±.03	.25	✓			
R .032	±.01	.032	✓			
R .38	±.03	.38	✓			
R .50	±.03	.50	✓			
R .75	±.03	.75	✓			
R .34	±.03	.34	✓			

<b>Measured by:</b> <i>[Signature]</i>
<b>Date:</b> 09/07/16

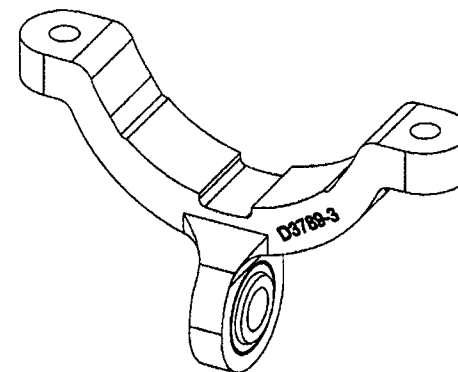
<b>Audited by:</b> <i>[Signature]</i>
<b>Date:</b> 09/07/17

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

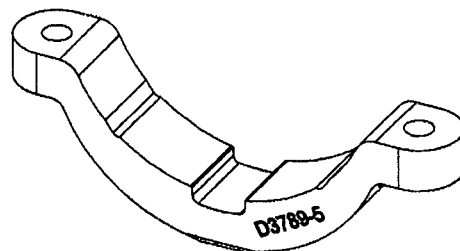
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A		New Issue	KJ/JLM	



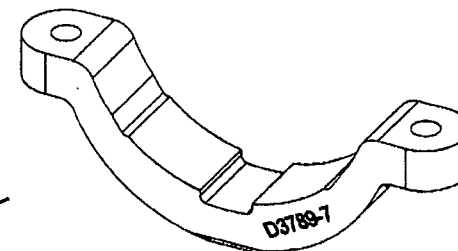
**D3789-1 CLAMP**



**D3789-3 CLAMP**



**D3789-5 CLAMP**



**D3789-7 CLAMP**

50525

DEO ATTACHED

RELEASED  
08/12/21

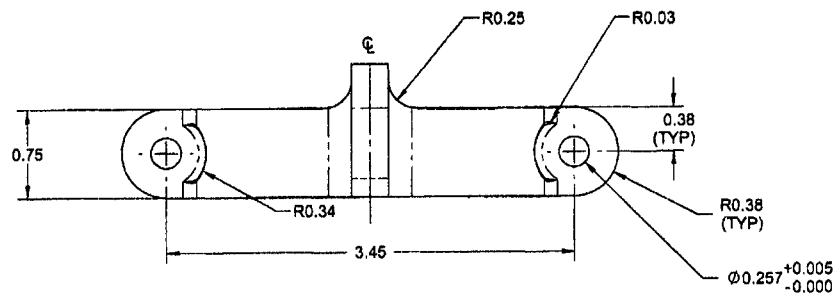
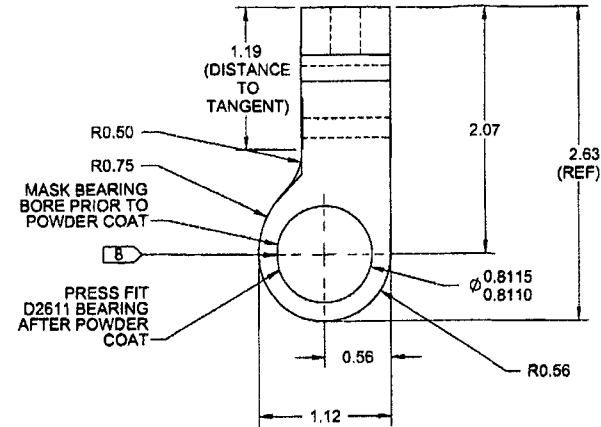
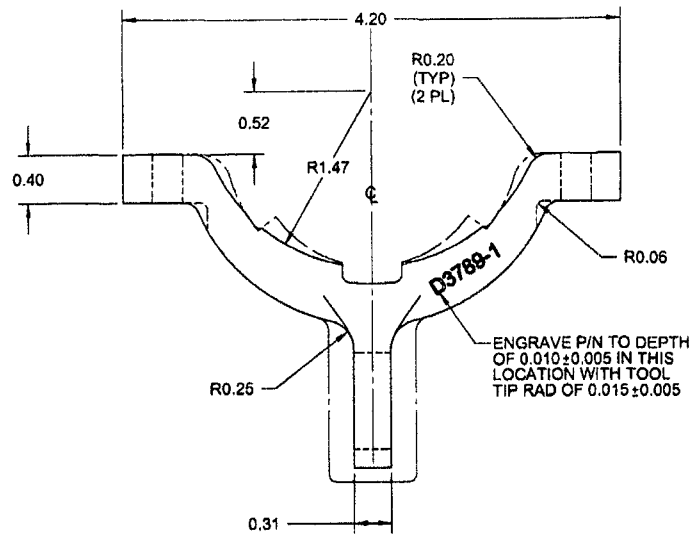
**NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs  
D3789-3, 0.16 lbs  
D3789-5, 0.14 lbs  
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMETRICAL ABOUT  $\phi$

A		NEW ISSUE		HS	08.05.21
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO <b>D3789</b> TITLE <b>CLAMP</b>		REV. A SHEET 1 OF 5 SCALE NTS	
DRAWN	HS				
CHECKED	HS				
MFG. APPR.					
APPROVED					
DE APPR.					
DATE		08.05.21			

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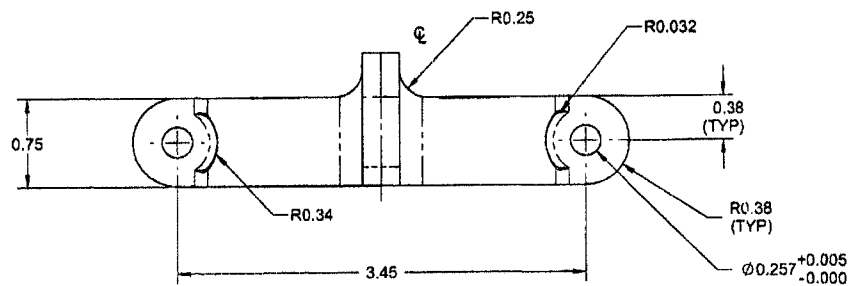
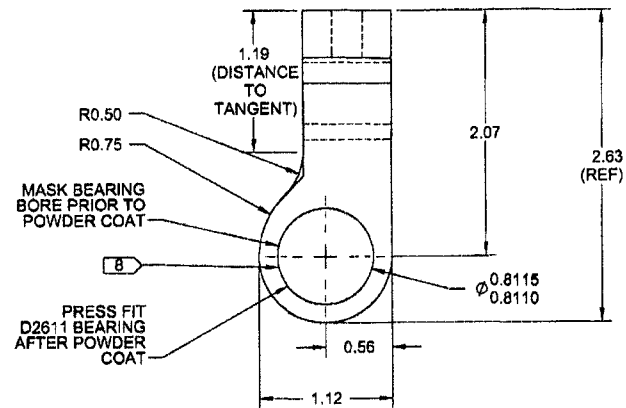
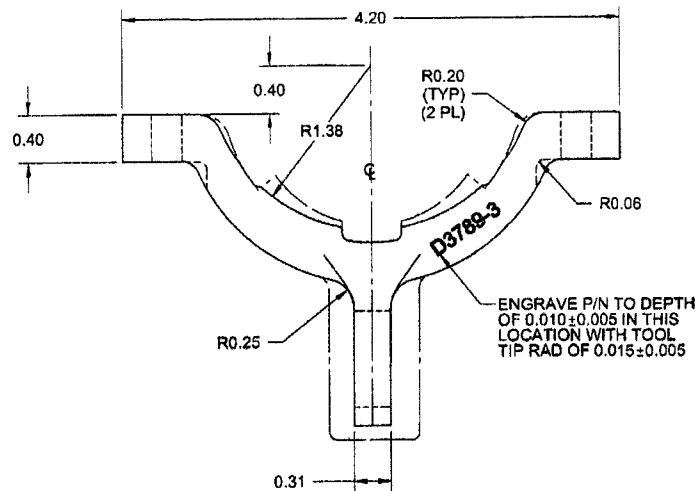
**D3789-1 CLAMP**

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RELEASED  
08/12/21

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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PW	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D3789	SHEET 2 OF 5
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	CLAMP	NTS
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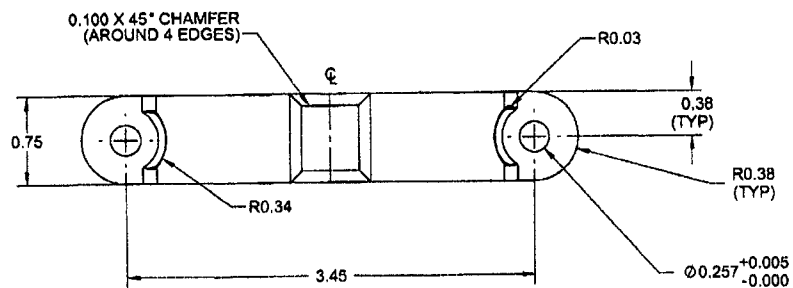
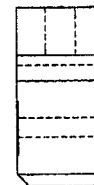
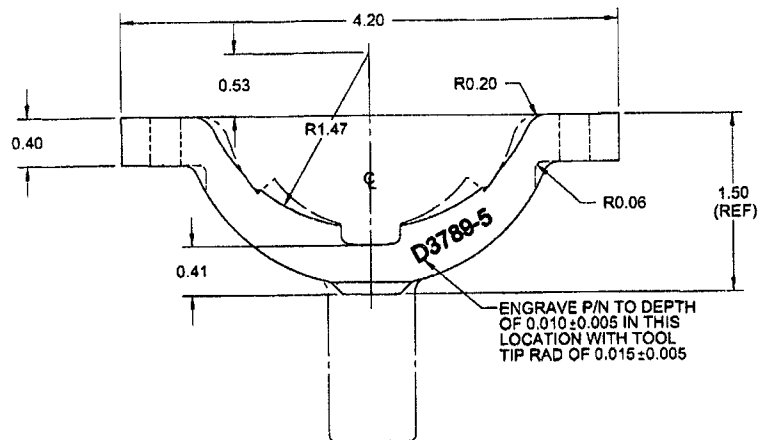
**D3789-3 CLAMP**

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CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	<b>D3789</b>	SHEET 3 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	<b>CLAMP</b>	NTS
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08/12/21



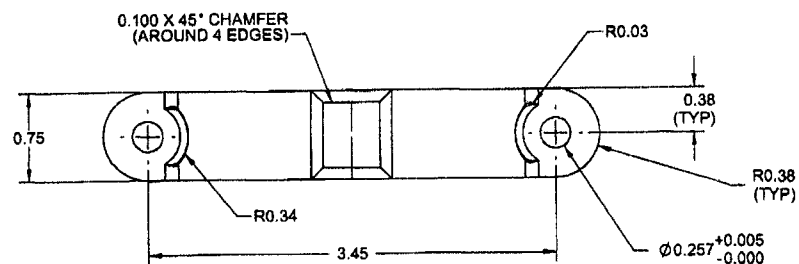
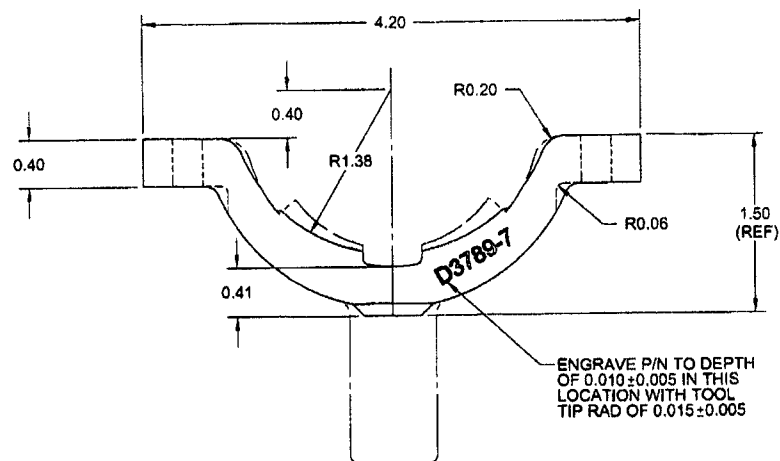
**D3789-5 CLAMP**

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**D3789-7 CLAMP**

50525

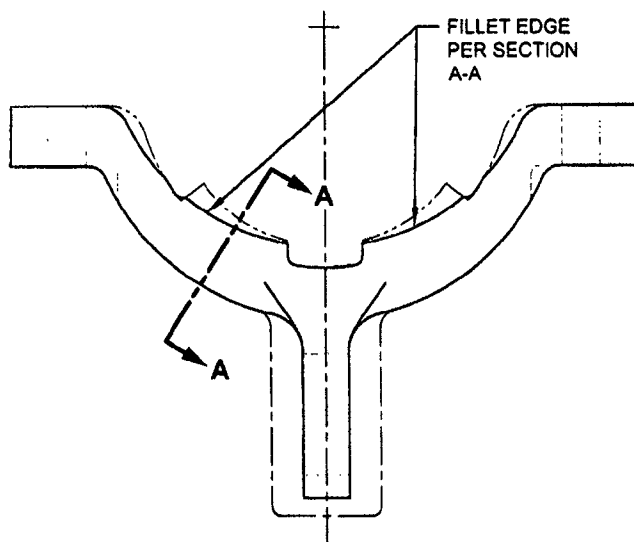
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3789	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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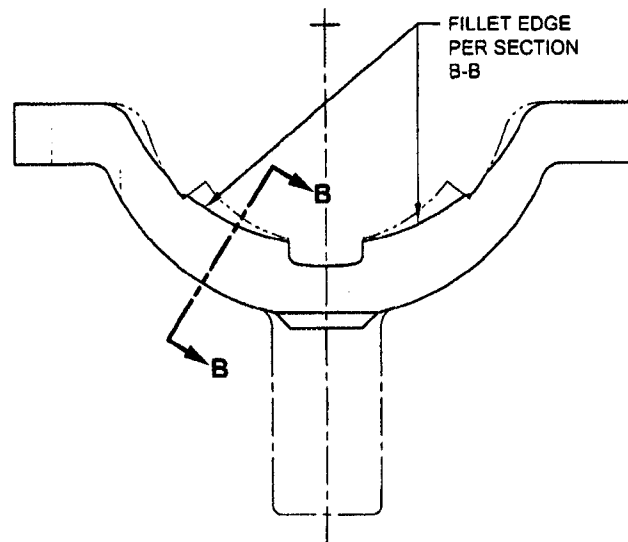
DRAWING NO. D3789	TITLE CLAMP	REV. A	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D3789-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>AJS</i>	CHECKED <i>b</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23	DATE 09/04/23		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



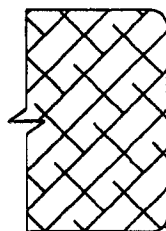
D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP



R0.06 MIN - R0.10 MAX  
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

*50525*

**RELEASED**  
*09/25/24 AM*

SEE PAR 122 FOR FURTHER DETAILS

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